

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026597**Date Inspected:** 26-Oct-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Salvador Merino**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

This Quality Assurance Inspector (QAI) was present at the SAS OBG segment 14W located at Pier 7. The following items were observed.

This QA Inspector randomly observed ABF personnel shortening traveler rail assembly 857mm per RFI 2516R0. The rail end plate with stopper cut off and reinstalled after removing the necessary length of rail. This QA inspector observed that the galvanizing in the area of the welds was removed by grinding.

The QAI periodically observed AB/F approved welder Jason Collins fit up and fillet weld the end plate with stop to the traveler rail utilizing the Shielded Metal Arc Welding (SMAW) process with AWS E-7018 filler metal per ABF – WPS - D15 – F1201A. AB/F QC Inspector Salvador Merino was present to verify fit up, monitor the progress and verify that the welding parameters were within the limits established by the approved WPS. The work appeared to be in general compliance with contract documents.

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Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Lanz,Joe	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
